

Work Order ID 148097***148097***

Page 1

Friday, June 24, 2016 10:43:30 AM

Item ID: D2572

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd, In

Start Date: 6/17/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/29/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	F								

100

0.02

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.38

HAAS CNC vertical machine #1

Program Batch No. **148 097**Double check by: *mf*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

6 0 16-07-12
DAS
44
9-89

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.16

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

6 0 16-07-11
DAS
44
9-89

148097

Friday, June 24, 2016 10:43:31 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/17/2016 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 6/29/2016 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.01

Quality Control

130

QC8- Inspect parts - second check

0.00

130

OC

Memo

0.02

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.03

Hand Finishing

**DAS
15
9-89**

Work Order ID 148097

Friday, June 24, 2016 10:43:31 AM

148097

Page 3

Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd, In
 Start Date: 6/17/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/29/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI006 4.3-Alum <i>M 134798</i> Memo START TIME: <i>2:40</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>3:10</i>	0.00 0.04				<i>6</i>	<i>0</i>	<i>16-07-19</i>	<i>2348</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>6</i>			<i>DAS 38 9-89 JUL 20 2016</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>51297</i> Memo	0.00 0.01				<i>6</i>			<i>DAS 9-89 JUL 21 2016</i>

Friday, June 24, 2016 10:43:31 AM

Item ID: D2572

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Fwd, In

Start Date: 6/17/2016 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 6/29/2016 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept	Qty
1	1
2	1
3	1
4	1
5	1
6	1
7	1
8	1
9	1
10	1
11	1
12	1
13	1
14	1
15	1
16	1
17	1
18	1
19	1
20	1
21	1
22	1
23	1
24	1
25	1
26	1
27	1
28	1
29	1
30	1
31	1
32	1
33	1
34	1
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36	1
37	1
38	1
39	1
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41	1
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80	1
81	1
82	1
83	1
84	1
85	1
86	1
87	1
88	1
89	1
90	1
91	1
92	1
93	1
94	1
95	1
96	1
97	1
98	1
99	1
100	1

Reject
Qty

Reject Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

DAS
21
9-89

JUL 21 2016

DAS
21
9-89

JUL 21 2016

Picklist Print

Friday, June 24, 2016 10:43:30 AM

Page 1

Work Order ID: 148097

148097

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd, In

Start Date: 6/17/2016

Required Date: 6/29/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	20.0000	1	6			

D6101-005

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

20

146278

20

147082

8

6

SP 16-07-10

DART AEROSPACE LTD	Work Order: 148092
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.498	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.500	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.124	.124	.125		
R	0.240	0.260		.250	.249	.251	.250		
S	0.115	0.135		.126	.125	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.243	.243	.243	.242		
W	0.115	0.135		.127	.126	.126	.125		
X	0.307	0.312		.307	.311	.311	0.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.251	.252	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.253	.246	.247	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	DAS
Date: 16-07-11 / 16-07-12	Date: 16-07-13	08
		9-88

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

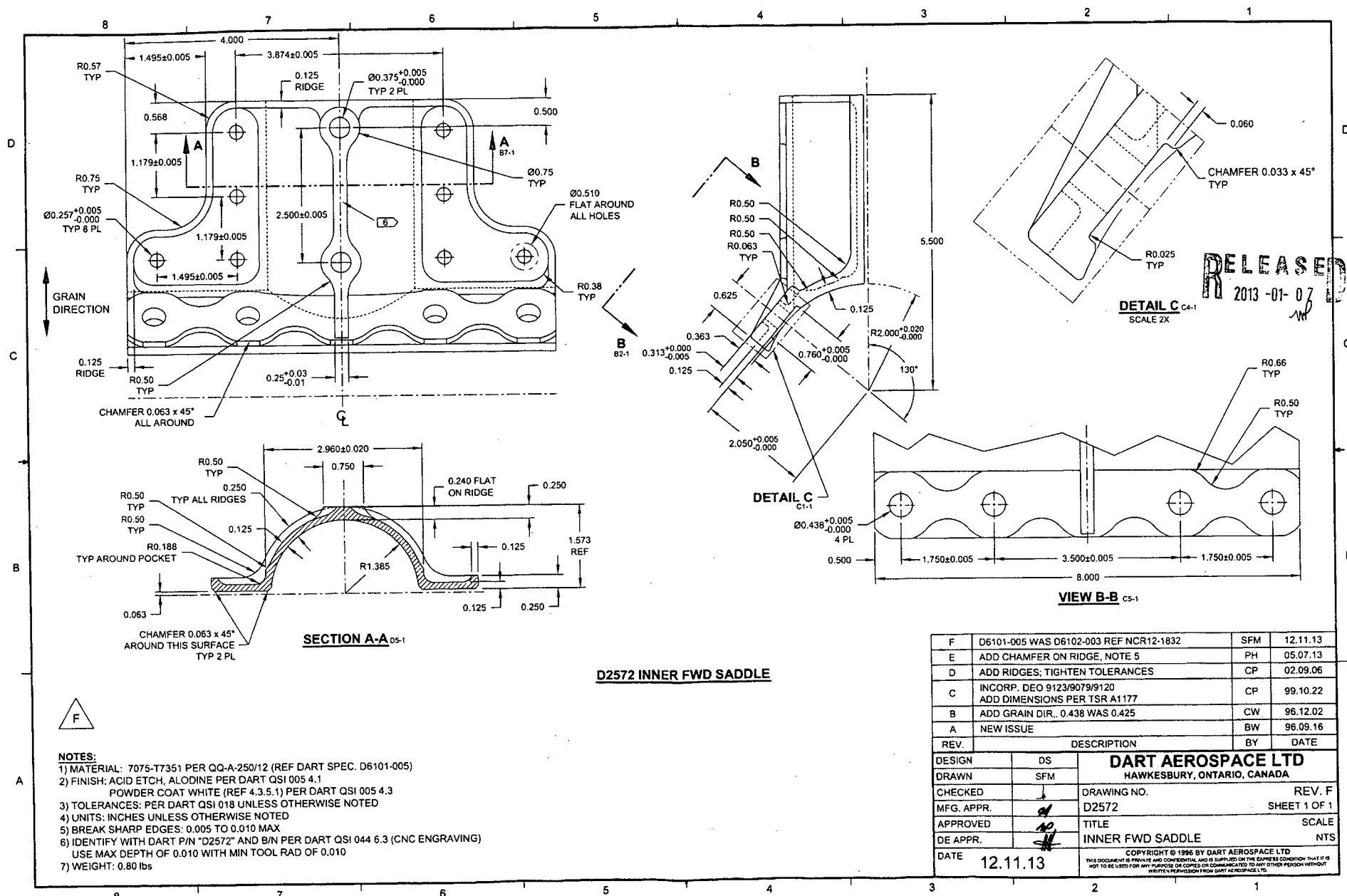
DART AEROSPACE LTD	Work Order: <i>148097</i>
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
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B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.498	.498				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.499	.499				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578	.567	1.179	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.135	.135				
Q	0.115	0.135		.126	.126				
R	0.240	0.260		.251	.251				
S	0.115	0.135		.125	.126				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.242	.241				
W	0.115	0.135		.124	.125				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.364	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.252	.251				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.276	.276				
AH	0.240	0.260		.248	.246				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject As									

Measured by: <i>44</i>	Audited by: <i>R.A.</i>	DA: <i>08</i>
Date: <i>16-07-12</i>	Date: <i>16/07/13</i>	9-8:

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



F	D6101-005 WAS D6102-003 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 5	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCCORP. DEO 9123/9079/9120 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR.. 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2572	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		INNER FWD SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	